Work Order ID 116956 *116956* Page 1 April-24-14 8:44:55 AM **Item ID:** D3436-043 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Step LH Start Date: *1* Start Qty: 1.00 4/23/14 **Cust Item ID:** Required Date: 4/23/14 **Reg'd Oty:** 1.00 *1* **Customer:** Reference: Run Start Date: 14-64-25 Tooling: Process Plan: MLJ **Approvals:** Date: Stop QC:_____ Date: SPC (Y/N): Date: Sequence ID/ Operation Reject Set Up/ ^ Tool ID Tool # Plan Reject Accept Insp. Work Center ID Qty Qty Number Description **Run Hours** Code Stamp Draw Nbr **Revision Nbr** D3436 Rev A 100 0.00 Large Fab [Q 14-6-27 *100* 0.00 Large Fab Memo Large Fab Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and Dwg D3436Dwg Rev: A Qty Part Number Description 4130 Welding Rod M 127915 Weld left step D3436-7 using welding Jig DT 110 0.00 1 9 14.1-27 **BAND SAW** *110* Bandsaw 0.00 Memo Jeaspa Bandsaw 1- Slit part D3436-041 on bandsaw as per Dwg D3436 2- deburr 120 QC9- Inspect visual per QSI004- Fusion Welds 0.00 DAS *120* 14-07.01

0.00

Memo

Quality Control

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Work Ord April 24-14 8:4		6956			*116	956*						Page 2
Item ID: Revision ID: Item Name:	D3436-043 Step LH				Accept	*N900	040	100)* s	etup Sta	17	IS1* IS2*
Start Date: Required Date: Reference:		Start Qty: 1.00 Req'd Qty: 1.00	J.	*1* *1*		Cust Item l Customer:	D:					
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Hand Finishing

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Work Ord April-24-14 8:-		6956			*116	3956*						Page 3
Item ID: Revision ID: Item Name:	D3436-043 Step LH				Accept	*N900	040	100)* s	Setup Sta	1.77	S1* S2*
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160

QC5- Inspect part completeness to step on W/O

0.00 PB 27 9-89 14/07/02

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Quality Control

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Work Orde April-24-14 8:4		6956		*116	3956*							Page 4
Item ID: Revision ID: Item Name:	D3436-043 Step LH		A	Accept	*N900	04 0	100)*	Setup	Start Stop	1/1	S1* S2*
Start Date: Required Date: Reference:	4/23/14 4/23/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		-				()/
Approvals:	Process Pla	nn:	Date:	Tooling: _ SPC (Y/N):		ite:			Run	Start Stop		R1* R2*
Sequence ID/ Work Center II 170 *170*)	Operation Description Identify as per dwg & Sto	ock Location: <u>570</u> 38		Tool ID	Tool#	Plan Code	Accept Qty	t Rej Qty	Di 2	Reject Number AS 88	Insp. Stamp
Packaging Packaging		Memo		0.00								

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QC21- Final Inspection - Work Order Release

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180

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Quality Control

MUS 1407-04 MH-7-3

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Picklist Print

April-24-14 8:44:58 AM

Work Order ID: 116956

116956

Parent Item:

D3436-043

D3436-043

Parent Item Name: Step LH

Start Date: 4/23/14

Required Date: 4/23/14

Page 1

Start Qty: 1.00

Required Oty: 1.00

Comments:

IPP .A 05.05.11New IssueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3436-1		Manufactured	No	·		100	Each	32.0000	1	1			
D3436-1									**	a	146	26	
:				Location		Loc	<u>Oty</u>	Loc Code					
į				WA002	96663		32		_		_		
D3436-3		Manufactured	No		96663	100	32 Each	6.0000	1 -	1			
D3436-3		Manuractured	0			100	Zaen	0.0000	** _	<u> </u>	14-6	5-27	
. 1				Location		Loc	<u>Otv</u>	Loc Code					
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,					95781		6		_		-		
D3436-5		Manufactured	No			100	Each	37.0000	4	4			
D3436-5									**	a	14-	576	···
, ţ				Location		Loc	<u>Oty</u>	Loc Code					
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					97483		4		_	ý.	_	/	DAS
D3436-9		Manufactured	No			100	Each	17.0000	2	2	_ /	′ /	36
D3436-9									**		14/0;	2/02	9-89
rad				Location		Loc	Otv	Loc Code	,				
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Part N	lo.					Scrap			Machining	Small Fab	7	Pro	d. Eng. Coor.	-	Quality
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	<u> </u>	Marks/Ch				Drill Holes	<u> </u>	Off-set							
	<u> </u>	Turning S				Finish	<u></u>	4	Calibration						
	Wave/Twist in Tube				Fit/Function	<u> </u>	Out of	Sequence						****	

Picklist Print

April-24-14 8:44:58 AM

Page 2

Work Order ID: 116956

116956

Parent Item:

D3436-043

D3436-043

Parent Item Name: Step LH

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 1.00

**

Required Qty: 1.00

D3436-7

Manufactured

160

Each

16.0000

Q 14.6-27

D3436-7

Cap

Location WA002

Loc Qty

Loc Code

16 16

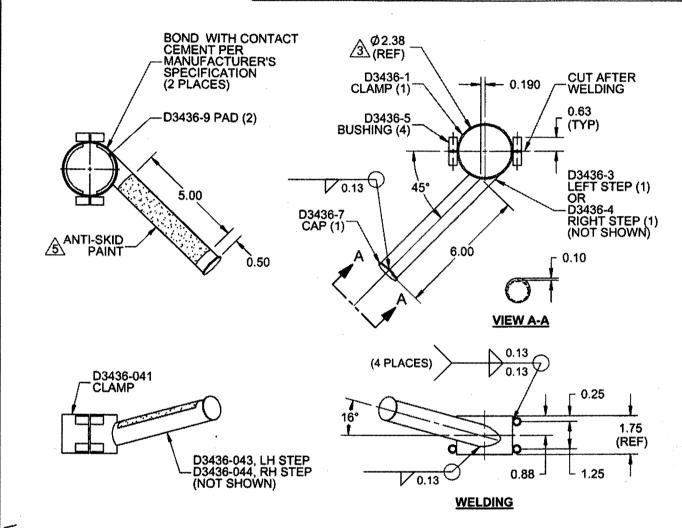
DQA:			Date:											TRACT
						WORK ORDER NON	-CC	ONFO	RMANCE / UPDA			,		AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only		
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		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqual	lified	Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		1	ions Incomplete/Uncle	 	Part Moved			Wrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V	/rong		
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge		Other
		Inspection	n Strip in	Tube		Drawing		Misread	d					
		Marks/Ch	atter			Drill Holes		Off-set						
] [Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence					···



DESIGN V	≀ IB	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECK	W	APPROVED #	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE	05.0)4.28	MAINTENANCE STEP	SCALE 1:4
 Α	0	5.04.28	NEW ISSUE	

RELEASEL

05.05.27



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
 2) WELD PER DART QSI 004
 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 7) ALL DIMENSIONS ARE IN INCHES

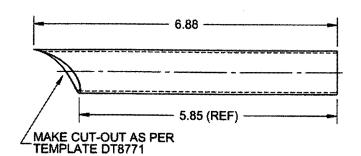
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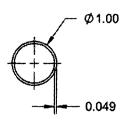
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16956 MC 4



-	DESIGN MB	DRAWN BY MB	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
	CHECKED	APPROVED	DRAWING NO. D3436	REV. A SHEET 3 OF 4
	DATE 05.0	4.28	MAINTENANCE STEP	SCALE 1:2

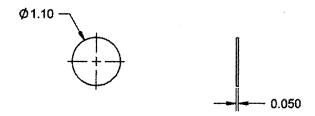




D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

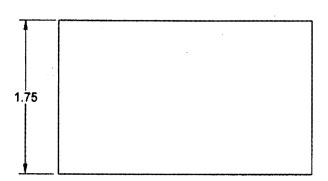
2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

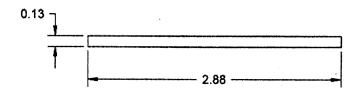
D3436-3/-7, GENERAL NOTES:

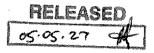
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED #	DRAWING NO. D3436	REV. A SHEET 4 OF 4
05.04.28		MAINTENANCE STEP	SCALE 1:1







D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF. DART SPEC. M-NEO60-S,125) 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

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